



Dart Aerospace Ltd.
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Tel (613) 632-5200
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D212-722-011
Job Sheet 203033



Part No: D212-722-011

Job Qty: 1 pcs

Part Name: Avionics Riser Console



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 11/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN-D212-722 REV A SHEET 7, DSI9476 REV A SHEET 2, D3363 REV C IPP Rev:B 05.04.11 Now made at Dart KJ/JLM IPP Rev:C 07-06-09 Holes now Transfer drilled JLM IPP REV:D 14.02.05 ADDED D212-722-013 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	11/22/19		0.00	0.80	Small Fab - 1		DAS 58 9-89 NOV 20 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	11/22/19		0.00	0.62	Handfinish - 1 - 1 - B4B		DAS 58 9-89 NOV 20 2019
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 -		

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					B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	11/22/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
140 Small Fab - 2 - B4B	1 pcs	11/22/19	0.00	0.87	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
150 QC 5	1 pcs	11/22/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	

DAS 30 9-89 NOV 20 2019

DAS 58 9-89 NOV 21 2019

				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS NOV 22 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	1	11/22/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
170	QC 4	1	11/22/19	0.00 0.00	QC 4 - 28
	pcs				QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
					QC 4 - 78
180	Packaging 3-2 - Stock - B4B	1	11/22/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B

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				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21 NOV 22 2019
185 DC - 1 - B4B	1	11/22/19	0.00 0.00	DC - 1 - B4B	9-50
	pcs			DC - 2 - B4B	
190 QC 21 - FG	1	11/22/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	21 NOV 22 2019
				QC 21 - SA - 53	9-50

Part Op 110 - (Small Fab) 1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360 Material: 6063-T52
 Descriptions: Aluminum angle 3/4" x 3/4" x 0.063" wall 2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum
 channel 3/4" x 3/4" x 0.125" wall 3-Deburr
 120 - Chemical Conversion Coat per QSI005 4.1
 130 - QC7-Inspect Chemical Conversion Coat
 140 - (Small Fab) 1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail I ***Mount Dzus Rails to
 DT8957 (Radio) and transfer drill into console. **** 2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363
 Identify as D3363-041 ATTN: INSTALL D3362-1, AND MAKE SURE THE RADIO THAT IS INSTALLED AT THIS PLACE
 FITS PRIOR TO CONTINUING TO MAKE HOLES.
 150 - QC5- Inspect part completeness to step on W/O
 160 - Pick Kit
 170 - QC4- 100% Inspect kits for completeness
 180 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D212-722-011
 185 - Document Control Photocopy bluefile and create labels per PPP D212-722-011 CHG003
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6063T5A0.750W.063	Angle6063T5 .750 X.750 X.063w	6.9000 ft (6.9 ea)	110-Small Fab - 1	5129241
M6063T5C.75X.75W.125	M6063T5C1.00X.500W.125	.8290 ft (.829 ea)	110-Small Fab - 1	fm1314790
PFSC35-38A	Dzus 1/4 Turn Fastener	8 pcs (8 ea)	110-Small Fab - 1	fm13130-1
D212-722-013	Fastener Brace Fg020	1 pcs (1 ea)	140-Small Fab - 2 - B4B	5282538
D3363-1	Console	1 pcs (1 ea)	140-Small Fab - 2 - B4B	5127637
MS20426AD4-5	Rivet	44 Ea (44 ea)	140-Small Fab - 2 - B4B	5fm1313094
PR35-1	Dzus Fastener Rail (\$ Per Foot)	.3333 ft (.3333 ea)	140-Small Fab - 2 - B4B	526272
MS20426AD4-6	Rivet	9 Ea (9 ea) ✓	170-QC 4	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	M6063T5A0.750W.063	7	15	0
	M6063T5C.75X.75W.125	1	21	0
	PFSC35-38A	8	36	0
140-Small Fab - 2 - B4B	D212-722-013 - 160-plc9 ✓	1	0	0
	D3363-1	1	6	0
	MS20426AD4-5	44	1,156	0
	PR35-1	0	3	0
170-QC 4	MS20426AD4-6	9	833	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

QTY Affected : _____

MRB (QS1042)

Date : _____ Sequence #: _____

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details:



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 1 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:5
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (Ø0.225 X 100') FROM TOP SIDE OF CONSOLE

C'SINK THIS SIDE (REF)

DETAIL C
(SCALE 1/2" = 1")
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125646-115
14-10-20

INSTALL D3361-1 & D3362-1 USING MS20426AD4-5 RIVETS (TYP 9 PLACES)

TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 48 PLACES) C'SINK (Ø0.225 X 100') FROM CONSOLE TOP SIDE

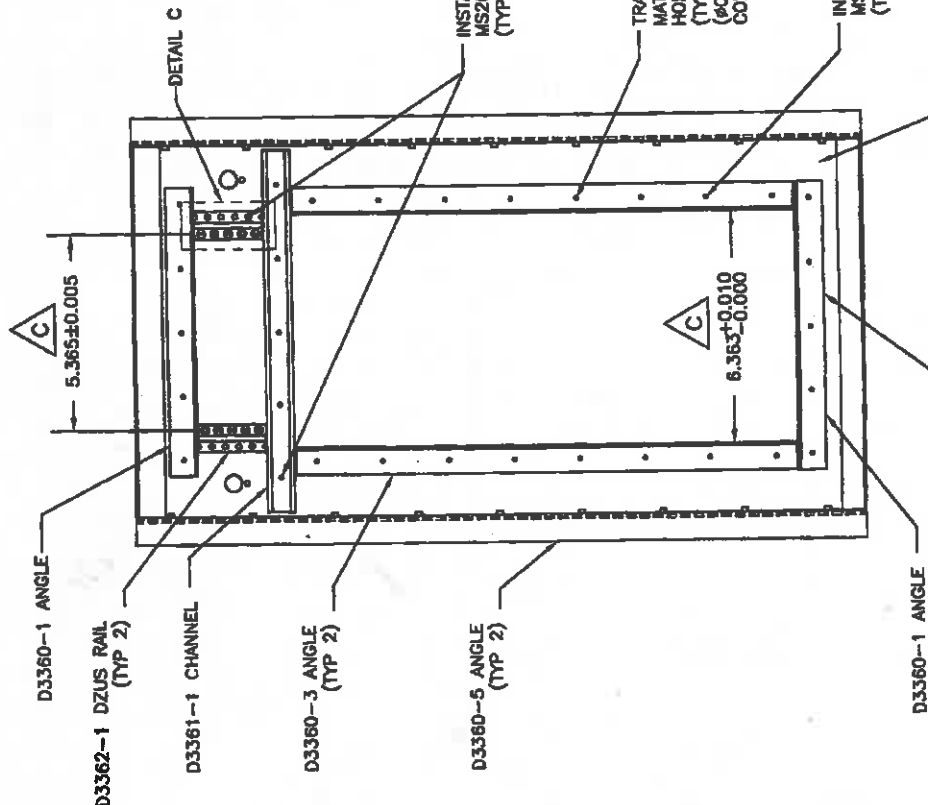
INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
1	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-5	RIVET

VIEW A-A FROM UNDER CONSOLE ASSEMBLY



- D3363-041 CONSOLE ASSEMBLY**
- ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
 - FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-722 REV. A

REF. TCCA STC: SH05-11
REF. FAA STC: SR02091NY
REF. EASA IM.R.S.01181

The purpose of the Service Instruction is to provide instructions for the installation of the D212-722-013 Dzus Rail Brace Kit which has been developed to provide a fastening method for the center dzus rail when the D212-722-011 Avionics Riser Console is installed. The D212-722-013 kit has been added to all D212-722-011 kits at CHG 003 or later.

If the aircraft pedestal has been removed from the aircraft follow the instructions in Option 1. If the pedestal has not been removed from the aircraft follow instructions in Option 2 (Sheet 2).

The maximum weight of equipment installed in front of the D212-722-011 Avionics Riser Console using the D212-722-013 Kit is 40 lbs.

Option 1 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to the correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the existing center PR35 dzus rails.
- 2) Remove the existing center dzus rail braces.
- 3) Clamp the D3986-1 angle, D3986-3 braces and PR35 dzus rail together as shown in Figure 1 (Sheet 3). The D3986-3 braces should be approximately centered between the existing dzus rails.
- 4) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 5) Transfer drill 9x $\varnothing 0.129$ (#30 drill) holes from PR35 dzus rail thru D3986-3 braces. See Figure 2, (Sheet 4), Note 1.
- 6) Deburr holes and reassemble using clecos.
- 7) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 2, (Sheet 4), Note 2.
- 8) Deburr holes and reassemble using clecos.
- 9) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from aircraft pedestal to D3986-3 braces. See Figure 2, (Sheet 4), Note 3.
- 10) Deburr holes, dimple D3986-3 brace and aircraft pedestal and reassemble using clecos.
- 11) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft pedestal. See Figure 2, (Sheet 4), Note 4.
- 12) Deburr holes, dimple D3986-1 angle and aircraft pedestal and reassemble using clecos.
- 13) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails.
- 14) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 2 (Sheet 4) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

A	NEW ISSUE	11.06.01
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.	N/A	
APPROVED		
DE APPR.		
DATE	11.06.01	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. DSI 9476		REV. A
TITLE DZUS RAIL BRACE KIT		SHEET 1 OF 7
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Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.

PARTS LIST

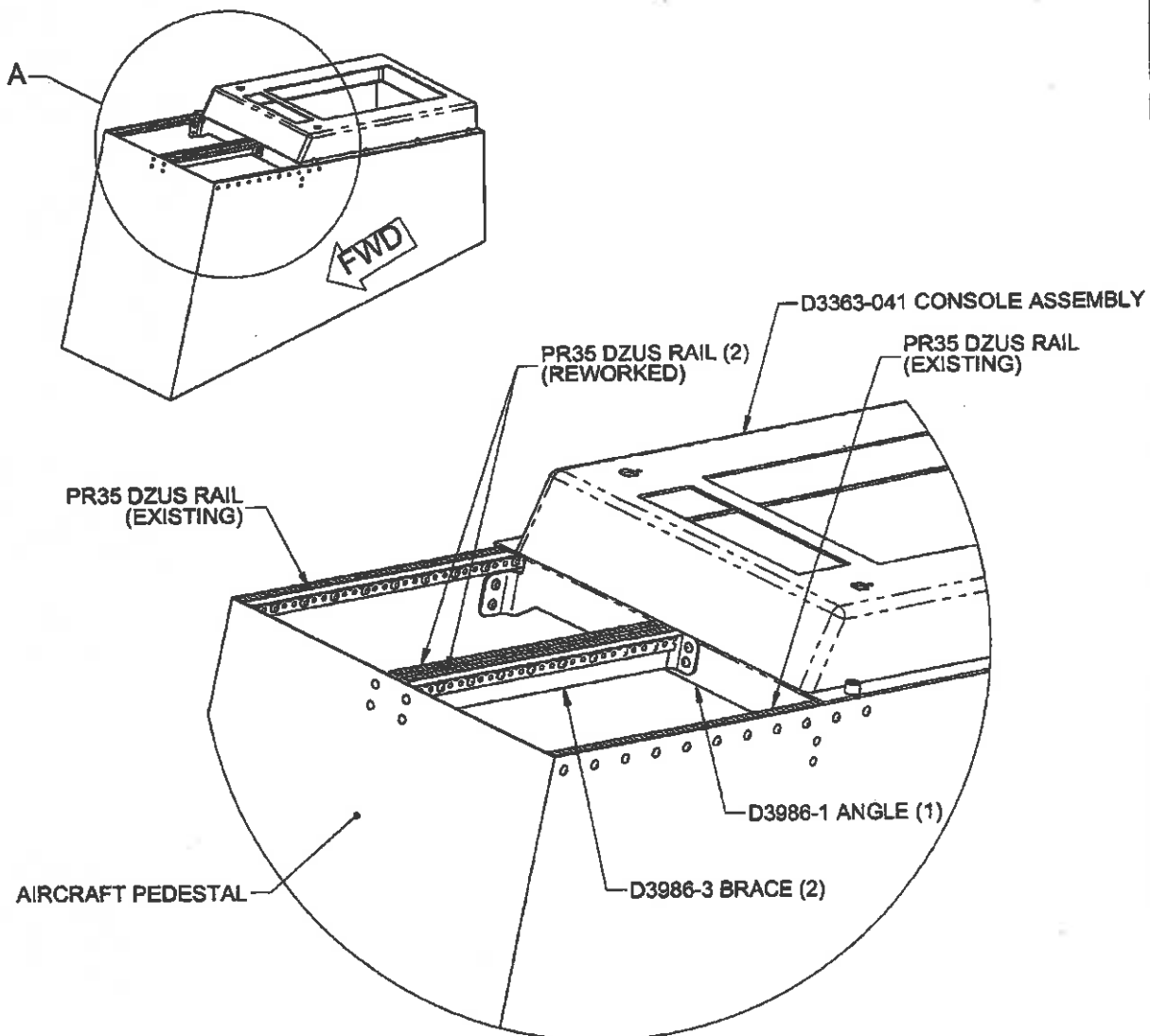
QTY. -013	PART NUMBER	DESCRIPTION
X	D212-722-013	DZUS RAIL BRACE KIT
1	D3986-1	ANGLE
2	D3986-3	BRACE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D SHEPHERD (DE # 02)

DATE: 11.06.01
CERT NO.: SH05-11
ISSUE NO.: 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9476	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DZUS RAIL BRACE KIT	NTS
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DETAIL A

FIGURE 1: D212-722-013 DZUS RAIL BRACE INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG APPR.	N/A	DSI 9476	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DZUS RAIL BRACE KIT	NTS
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4.0 WEIGHT AND BALANCE

The following weight and balance information does not include the installation of any equipment in the D212-722-011 Avionics Riser Console Assembly.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D212-722-011 Avionics Riser Console	2.3 lb 1.1 kg	0 in 0 m	0 lb-in 0 kg-m	37 in 0.9 m	85.1 lb-in 1.0 kg-m

5.0 PARTS LIST

Qty – 011	Part Number	Description
	D212-722-011	AVIONICS RISER CONSOLE
	D3368-011	CONSOLE ASSEMBLY
	D50025-011	DZUS FASTENERS
REF	D1038-58	FASTENER RAIL
REF	D1038-58B	FASTENER RAIL, BLACK
REF	PR35	DZUS RAIL